Work Order ID 59426 Page 1 Friday, June 04, 2010 9:23:30 AM Accept Item ID: D3532-1 Setup Start **Revision ID:** Stop Spacer Item Name: 6/4/2010 Start Qty: 20.00 **Start Date: Cust Item ID: Required Date: 6/10/2010** Req'd Qty: 20.00 **Customer:** Reference: Run Start Date: 164-04 Tooling: Process Plan: Date: **Approvals:** Stop Date: SPC (Y/N): Date: QC: Reject Reject Sequence ID/ **Tool ID** Tool # Plan Accept Insp. Operation Set Up/ Number **Work Center ID** Code Qty **Qty** Stamp Description **Run Hours Draw Nbr Revision Nbr** D3532 Rev A 100 0.00 Hardinge CNC LATHE SMALL 0.00 Hardinge Memo 1-TURN AS PER FOLIO FA64 & DWG D3532,□FOLIO Hardinge CNC Lathe Small REV: ____□DWG REV: / □2-DEBURR AS REQUIRED 0.00 110 QC2- Inspect parts off machine FAI/FAIB 0.00 QC Memo Quality Control 1001/09 ml 10/07/09 120 QC8- Inspect parts - second check

Quality Control

Memo

0.00

22 8

Dart Ae	rospace Lt	d							2
W/O:			WO	RK ORDER CHANGES					
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Port No		DAD #	F# 0-4						
Part No: PAR #:									
	Reso			n: (Date: _	
NCR:			WORK ORDE	ER NON-CONFORMANO	CE (NCF	₹)			
DATE	E STEP Description of NC Section A	Description of NC		Corrective Action Section B		Verific	ation	Approval	Approva
DATE		Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section		Chief Eng	QC Inspect	
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Work Order ID 59426

Page 2

Friday, June 04, 2010 9:23:30 AM

Required Date: 6/10/2010

D3532-1

Accept



Setup Start



Revision ID:

Item Name:

Start Date:

Spacer

6/4/2010

Start Qty: 20.00 Req'd Qty: 20.00

Cust Item ID: Customer:

Tool ID

Reference:

Process Plan:

Date:_____

Tooling:

Date:

Start Run

Reject

Qty



Approvals:

QC: ___

SPC (Y/N): Date:

Date:

Tool # Plan

Code

Stop

Stop

Number Stamp

Insp.

Sequence ID/ **Work Center ID**

130

Packaging Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

Set Up/ **Run Hours**

0.00

0.00

Accept

Qty

Reject

140

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

1/1003-12 MF 10-7-9

Dart Ae	rospace	e Ltd						
W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty			

Part No:		PAR #:	Fault Category:	NCR: Yes No DQ	A: Date: _	
	Resolution:		Disposition:	QA: N/C Closed:	Date:	
ICD.			WORK ORDER NON-COM	VEORMANCE (NCR)		

Approval Chief Eng / Prod Mgr

Approval QC Inspector

NCR:			WORK ORDE	ER NON-CONFORMANC	JE (NCK)			
		Description of NC	Verification	Annual	Ι			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
						5		
	1.							
) }

Picklist Print

Friday, June 04, 2010 9:23:38 AM

Work Order ID: 59426

Parent Item: D3532-1

Parent Item Name: Spacer

Comments:

IPP Rev:A New Issue 06-07-12 EC

Start Date: 6/4/2010

Start Qty: 20.00

Required Date: 6/10/2010

Page 1

I

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR0.750		Purchased	No		-		f	83.0100	0.03	0.6	-		
										0.0			

Delrin Round Bar 0.75"

Location	Loc Qty	Loc Code
MAT	51.1	
114595	51.1	
MAT050	31.91	
112418	0.12	
112480	31.79	

-6# 5/ Woto9

Dart Aerospace Ltd	Dar	t Ae	rost	oace	e Ltd
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W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PROCEDURE CHANGE By Date					ty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		·								
Part No	•	PAR #:	Fault Cate	egory:	NCR: Yes	No DQA:		Date:		
Resolution:			Disposition	on:	QA: N/C Closed:			Date:		
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)					
DATE	STEP	Description of NC		Corrective Action Section		Verificati	on I	Approval	Approval	
	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector		

		c.								

DART AEROSPACE LTD	Work Order:	59474
Description: Spacer	Part Number:	D3532-1
Inspection Dwg: D3532 Rev: A		Page 1 of 1

	FIRST ARTICLE INSPECTION CHECKLIST								
	X	First Article	• <u> </u>	Prote	otyp	e			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Rej	ect	Method of Inspection	C	Comments	
Ø0.625	+0.008/-0.001	1 2,629	/						
Ø0.391	+0.006/-0.001		/						
0.260	+/-0.010	-258							
					_				
									
 				-					
Measured by:	13	Audited by:			Dro	totype Approv	al:	N/A	
Date:	() (1/2)	Date:	- rz	_	-10	Da	-+	N/A N/A	
Date:	10/0/7/0/	Date:	10/07/09					IV/A	
Pov Date	Pey Date Change Revised by Approved								

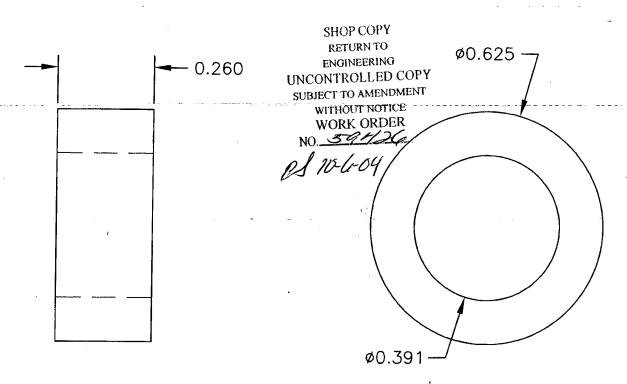
Rev	Date	Change	Revised by	Approved
Α	07.10.09	New Issue	KJ/EC/DD	R
			7 [1]	

Dart	Aeros	pace	Ltd
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W/O:		WORK ORDER CHANGES								
DATE	STEP	PRO	PROCEDURE CHANGE			Ву	Date	Oty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:								
	R	esolution:							Date:	
NCR:	,	V	VORK ORI	DER NON-CONF	ORMANCE	: (NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Description Chief Eng	Section B ption	Sign & Date	Verifica Sectio		Approval Chief Eng	Approval QC Inspector
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DESIGN PH	DRAWN BY	DART	AEROSPACE USA, INC.
CHECKED	APPROVED	D3532	REV. A SHEET 1 OF 1
DATE		TITLE	SCALE
06.06.26		SPACER	4:1
A	06.06.26	NEW ISSU	JF



D3532-1 SPACER

D3532-1 SPACER

- 1) MATERIAL:
- DELRIN ROUND BAR (REF. DART SPEC. M-DELRIN-RD.DDD)
- 2) FINISH:
- NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES



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	Dart	Aeros	pace	Ltd
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W/O:				VORK ORDER CHAI	NGES			l			
DATE STEP		PROCEDURE CHANGE				Ву	Date Q	ty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #:	Fault Ca	tegory:	NCE	P. Vas	No. DOA:		Date		
Part No: PAR #:			Disposition:						Date: Date:		
NCR:				DER NON-CONFOR				l			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action S Action Description Chief Eng	Section B	Sign &	Verification Section C		Approval Chief Eng	Approval QC Inspector	
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